

Date: Friday, 23/05/2008 9:56:30 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BEARPAW
Job Number :	39442		
Estimate Number :	11647		
P.O. Number :		Part Number :	D2995
This Issue :	23/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2995 REV A1
First Issue :	//	Project Number :	N/A
Previous Run :	28715	Drawing Revision :	A1
Written By :		Material :	
Checked & Approved By :	<u>JLD 08.5.23</u>	Due Date :	12/06/2008
Comment :	Est A 01.03.07 New Issue EC	Qty:	10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Batch Log



Comment: Qty.: 2.7777 sf(s)/Unit Total: 27.7770 sf(s)

Pick:

Material: Black UHMW 1"

Batch M108013

H.A

08/06/04

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS CNC VERTICAL MACHINING #1

Cut blank: 19.50" x 20.00"

Inspect material for defects or damage prior to machining

Machine as per folio FA119

Deburr

H.A / *[Signature]*

08/06/08

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEH.A / *[Signature]*

08/06/08

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

J.L

08/06/10

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 39425

AS 08/06/10

(X16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 9:56:30 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW

Job Number: 39442

Part Number: D2995

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/10 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



le 08.06.10

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DART AEROSPACE LTD		Work Order: 39442
Description: Bearpaw		Part Number: D2995
Inspection Dwg: D2995	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.625	+/-0.010	0.618	✓			
0.250	+/-0.010	0.249	✓			
R0.25	+/-0.030	R 0.25	✓			
0.25 x 45°	+/-0.030 x 0.5°	0.245 x 45°	✓			
5.86	+/-0.030	5.864	✓			
0.950	+/-0.010	0.952	✓			
0.433	+/-0.010	0.432	✓			
19.00	+/-0.030	19.00	✓		tape	
4.25	+/-0.030	4.253	✓			
3.63	+/-0.030	3.625	✓			
7.375	+/-0.010	7.375	✓			
11.625	+/-0.010	11.625	✓			
0.38	+/-0.030	0.385	✓			
3.081	+/-0.010	3.071	✓			
17.73	+/-0.030	17.715	✓			
19.34	+/-0.030	19.34	✓		tape	
Ø0.260	+0.006/-0.001	Ø0.260	✓			
0.30	+/-0.030	0.308	✓			
Ø0.93	+0.004/-0.001	Ø0.930	✓			

Measured by: H.A/mk	Audited by: DDP	Prototype Approval:	N/A
Date: 08/06/08	Date: 08/06/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.02	New Issue	KJ/JLM	EE

Dart Aerospace Ltd

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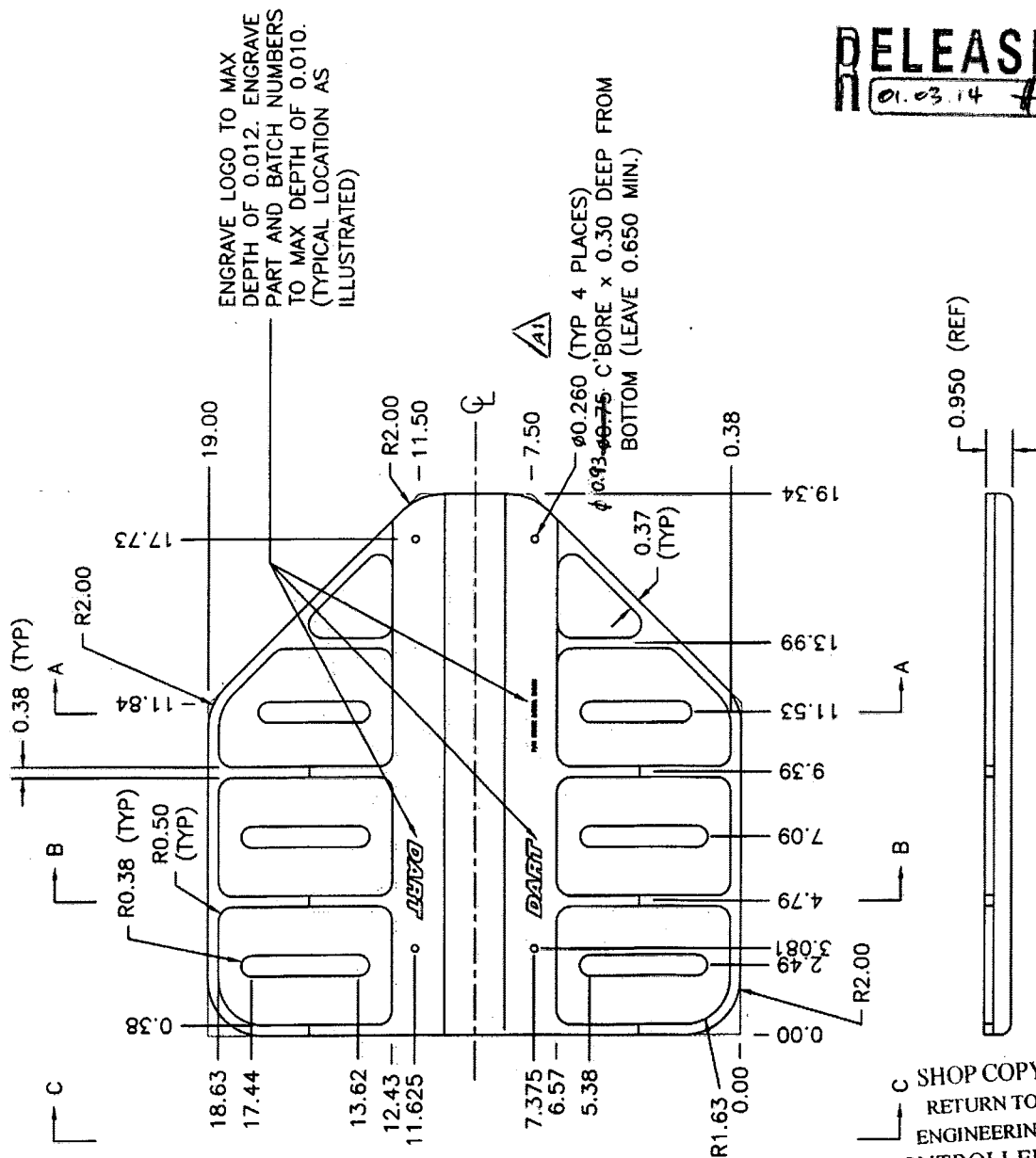
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DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2995	REV. A SHEET 1 OF 2
DATE 01.02.23				TITLE BEARPAW	SCALE 1:6
A	01.02.23			NEW ISSUE	
AI	# 03.01.06			Ø 0.93 was Ø 0.75	

RELEASED
01.03.14



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WITHOUT NOTICE
WORK ORDER
NO. 39442

BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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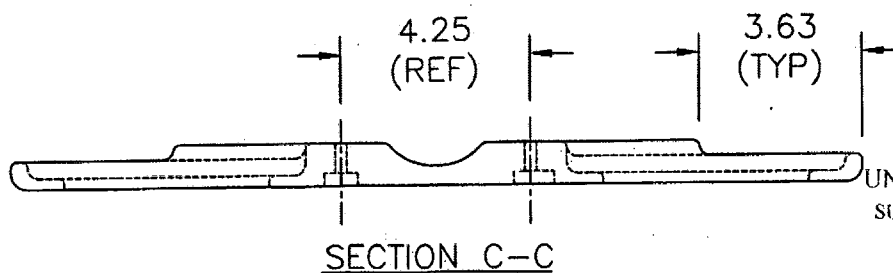
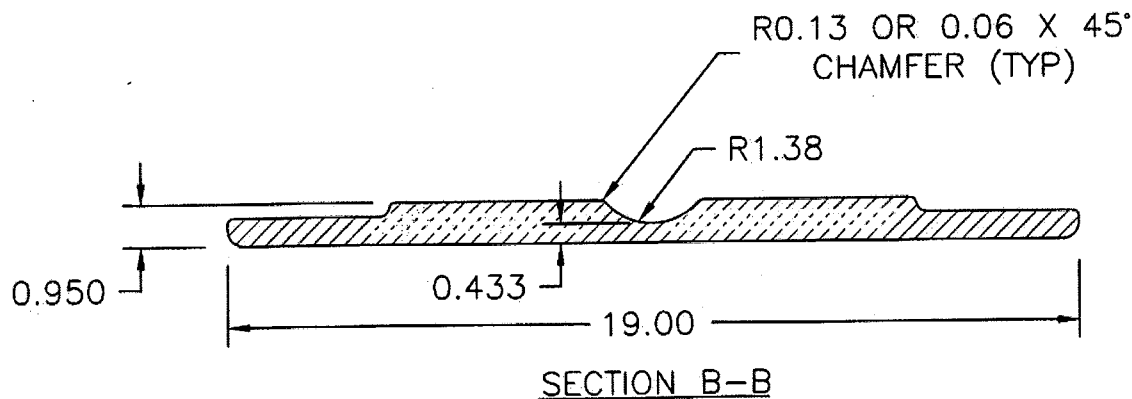
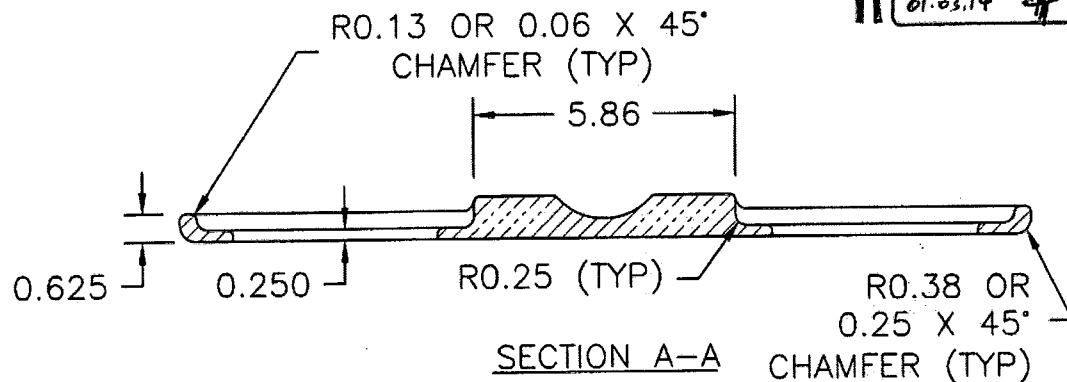
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2995	REV. A SHEET 2 OF 2
DATE 01.02.23		TITLE BEARPAW	SCALE 1:4

RELEASED
01.03.14 #

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